



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4909-1TRN
Job Sheet 171037



SOLD
Feb 10

Part No: D4909-1TRN

Job Qty: 4 ea

Part Name: Support Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/26/18

Job Tracking No:

Due Date: 2/5/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-04-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/2/18	0.00	0.00	Start Up Machining-3		<i>18/02/05</i>
100	Doosan	4 pcs		2/5/18	0.00	11.23	Doosan		<i>18/02/05</i>
110	QC	4 pcs		2/5/18	0.00	0.00	QC2 Machining-3		<i>18/02/05</i>
120	QC	4 pcs		2/5/18	0.00	0.00	QC8 Machining-3		<i>18/02/05</i>
130	Packaging	4 pcs		2/5/18	0.00	0.00	Packaging1-5		<i>18/02/05</i>
140	QC21-SA	4 Ea		2/5/18	0.00	0.00	QC21		<i>DAG</i>

Part Op **100** - Turn blank as per Folio FB189 ENSURE TO TEST FIT ID BORE WITH 4TH AXIS PLUG /FIT MUST SNUG****
Descriptions: **130** - LOCATION: MAT060

FEB 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6104-011	17-4 SS Roundbar 6.50"OD	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6104-011	4	22	0

Part Specifications

Specifications could not be found.

Plex 1/26/18 7:32 AM dart.lacelle.linda

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

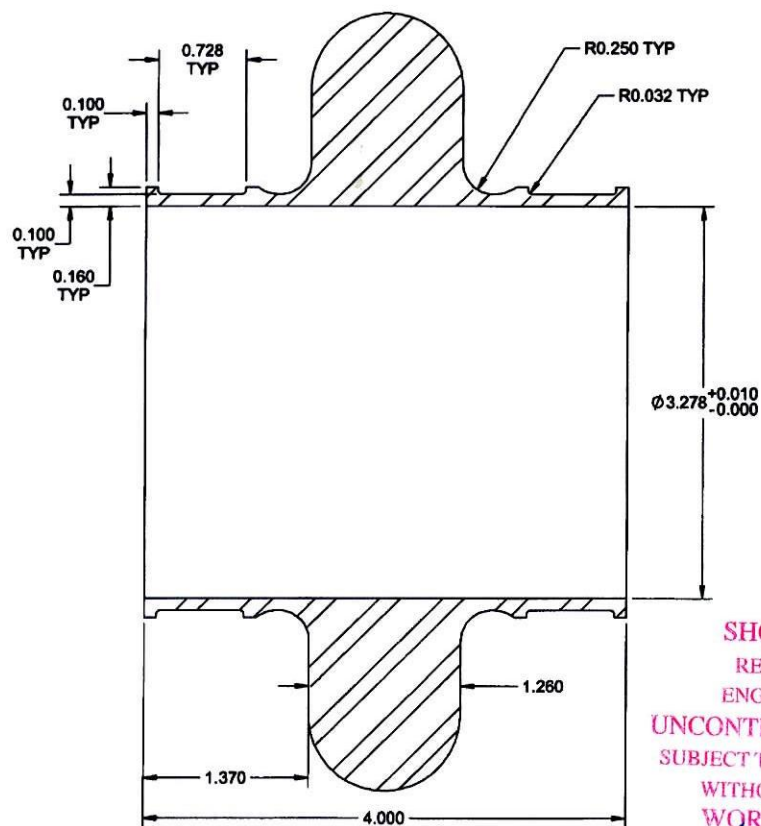
DART AEROSPACE LTD		Work Order:	171087
Description: Turning Detail for D4909-1		Part Number:	D4909-1TRN
Inspection Dwg: D4909		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Milling Section								
A-A	3.268	3.288		3.282	3.280	3.281	3.280	
B-B	1.250	1.270		1.258	1.258	1.258	1.258	
C-C	3.990	4.010		4.000	4.000	4.000	4.000	
D-D	0.718	0.738		0.728	0.728	0.728	0.728	
E-E	0.150	0.170		0.154	0.156	0.155	0.154	
F-F	0.090	0.110		0.095	0.098	0.097	0.097	
G-G	0.090	0.110		0.100	0.100	0.100	0.100	
H-H	R0.022	R0.042		0.032	0.032	0.032	0.032	
I-I	R0.240	R0.260		0.250	0.250	0.250	0.250	
J-J								
K-K								
L-L								
M-M								
N-N								
O-O								
P-P				✓	✓	✓	✓	

Measured by:	<i>[Signature]</i>	Date:	18/02/05
Audited by:	<i>[Signature]</i>	Date:	18/02/05
Preliminary Approval:		Date:	

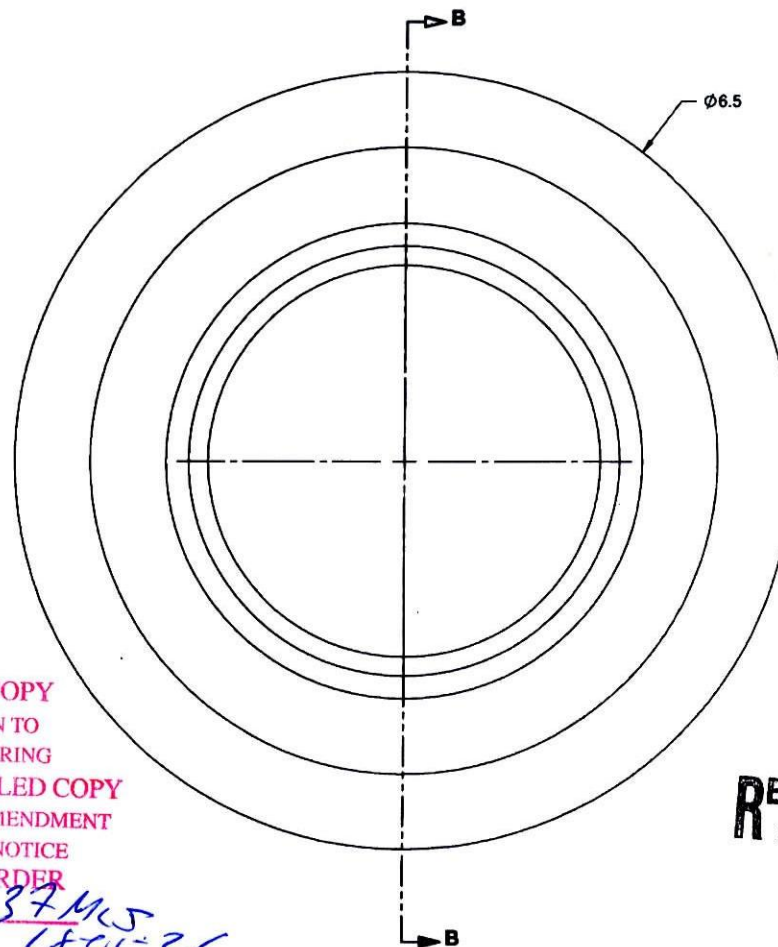
Rev	Date	Change	Revised by	Approved
A	14.07.07	New Issue	KJ	<i>[Signature]</i>



SECTION B-B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *171037 MJS*
18-01-26

D4909-1TRN TURNING DETAIL



RELEASED
2013-08-06

NOTES:

- 1) MATERIAL: 17-4PH / S17400 / TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R
HEAT TREAT TO H900 CONDITION (900 °F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.1 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4909	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
DATE	13.04.08	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR EXPOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART
AEROSPACE
S038875

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Support Turning Detail

PART NO: D4909 – 1TRN

Original Serial #: S038875

Revision:

Operation: Start up Operation 02/05/18

Change No:

Job No: 171037